

Date: Thursday, 24/07/2008 8:24:44 AM  
 User: Melanie Fauteux

## Process Sheet

Duplicate

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: AFT ADJUSTABLE BLADE SUPPORT ASSY
Job Number	: 40609 -1	Part Number	: PB674300117
Estimate Number	: 13434	Drawing Number	: B6743001 P.7
P.O. Number	:	Project Number	: N/A
This Issue	: 24/07/2008 S.O. No. :	Drawing Revision	: B1
Prsht Rev.	: NC	Material	:
First Issue	: 17/07/2008 Type : LARGE FAB ASSY	Due Date	: 24/07/2008 Qty: 5 Um: Each
Previous Run	:		
Written By	:		
Checked & Approved By	: <u>MF 08-07-24</u>		
Comment	: Est Rev:A 08-06-26 new issue DD verified by:ec		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PB6743001259	Inner Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Inner Tube

batch: 340578

2.0	PB6743001249	Inner Tube Bushing
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Inner Tube Bushing

batch: m10531

3.0	PB6743001253	Gusset
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Gusset

batch: 340045=2 40717=3

4.0	PB6743001254	Gusset
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Gusset

batch: 340053

5.0	PB674300171	PB67-43001-71
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

PB67-43001-71

batch: 340027





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Part Number: PB674300117

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- make a 0.090" chamfer in the 1.00" hole before welding

2- assemble parts and weld as per dwg

*PK 08-07-24*

7.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*PD 08-07-24 (5)*

8.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*S 08/07/29 (28)*

9.0 MS124780 HELICAL INSERT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

HELICAL INSERT

*M17935*

*PK*

10.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- grind weld flush in area of PB67-43001-249 only

2- tap drill for helicol

3- install helicol insert as per dwg

*PK 08-07-30*

*(5)*

11.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*S 08/07/30 (X5)*

12.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*N/A*

13.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

*M102316*

*(5X)*

1- MASK TUBE FROM BASE TO GUSSET

2- Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

*M-P 08/07/31*





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Part Number: PB674300117

Job Number:



Seq. #:

Machine Or Operation:

Description :

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:00  
320°F  
1:30

M-A 08/07/31

(52)

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 08/07/31

(5)

15.0

PB674300173

20 Degree Cover Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)  
20 Degree Cover Plate  
batch: 40094

08.08.26 5

16.0

PB674300183

PB67-43001-83



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)  
PB67-43001-83  
batch: 40096

08.08.26 5

17.0

MS27039110

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total: 40.0000 Each(s)  
Screw  
batch: 18836

08.08.26 5

18.0

NAS1149F0316P

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total: 40.0000 Each(s)  
WASHER  
batch: 106242

08.08.26 5

19.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- match drill cover to existing holes in support  
2- assemble as per dwg

08.08.26 5



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Machine Or Operation:

Description :

20.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/08/26 #3

21.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: \_\_\_\_\_

39952

22.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/26  
#4

Job Completion



W 08.08.26







